

Work Order ID 122576

Tuesday, July 22, 2014 8:40:24 AM

122576

Page 1

Item ID: D4635-141 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Ceiling Replacement Panel Assembly, LH
 Start Date: 8/19/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/19/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 140723 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4635	E								

100

0.00

100

HandThermo

Hand Finishing Thermoforming

Memo

Pick Kit

0.00

DAS
27
9-88

14/9/10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00						DAS 27 9-89	
110									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D4635-141 Bond foam core to inside of panel 3M Scotch Weld 1300 Batch: <u>129879</u>								
	1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe								
	2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8)								
	Batch # <u>M/29001</u>								
	Expiry Date <u>3/17/2015</u>								
	3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9)								
	Batch: <u>124725</u>								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

4/9/10

38
9-89

14-9-11

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Operator									
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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

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MLJ 14-09-11

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122576

D4635-141

Start Date: 8/19/14**Required Date:** 8/19/14**Start Qty: 1.00**

Required Qty: 1.00

IPP Rev B

Dwg. Update 12/11/08 DL

IPP Rev C Dwg. Update

13/07/09 DL verf:DD

IPP Rev. D Dwg Update Add Foam

13/12/23 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5022-1		Manufactured	No			100	Each	22.0000	1	1			
									**				DAS 27 9-89
D5022-1													
Foam, Side Panel, Fwd													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF		22							
					116252	9							
					117535	13							
D4635-1		Manufactured	No			100	Each	0.0000	1	1			
									**				DAS 27 9-89
D4635-1													
Fwd Ceiling Panel, LH													
D4695-041		Manufactured	No			100	Each	7.0000	1	1			
									**				
D4695-041													
Channel Assembly, LH													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF1		6							
					117669	6		B122681					
				ST229B		1							
					113881	1							
D4669-1		Manufactured	No			100	Each	20.0000	2	2			
									**				DAS 27 9-89
D4669-1													
Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF4		20							
					117667	20		B22474					

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FAULT CATEGORY

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Picklist Print

Page 2

Tuesday, July 22, 2014 8:40:23 AM

Work Order ID: 122576

122576

Parent Item: D4635-141

D4635-141

Parent Item Name: Fwd Ceiling Replacement Panel Assembly, LH

Start Date: 8/19/14

Required Date: 8/19/14

Start Qty: 1.00

Required Qty: 1.00

D4732-5

Manufactured No

100

Each

20.0000

1

1

D4732-5

Label

******LocationLoc QtyLoc Code

MF

19

120062

19

ST122

1

111261

1

DAS

27
9-89

14/9/10

D4732-9

Manufactured No

100

Each

19.0000

1

1

D4732-9

Label

******LocationLoc QtyLoc Code

MF4

19

120065

19

DAS

27
9-89

14/9/10

D4732-29

Manufactured No

100

Each

19.0000

1

1

D4732-29

Label

******LocationLoc QtyLoc Code

MF

19

120075

19

DAS

27
9-89

14/9/10

D4732-33

Manufactured No

100

Each

19.0000

1

1

D4732-33

Label

******LocationLoc QtyLoc Code

MF

19

120077

19

DAS

27
9-89

14/9/10

Tuesday, July 22, 2014 8:40:23 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

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122576

Parent Item: D4635-141

D4635-141

Parent Item Name: Fwd Ceiling Replacement Panel Assembly, LH

Start Date: 8/19/14

Required Date: 8/19/14

Start Qty: 1.00

Required Qty: 1.00

MPNY-750S-9-C

Purchased

No

100

Each

411.0000

7

7

MPNY-750S-9-C

Mounting Pad

Location

Loc Qty

Loc Code

MF4

411

124058

1

M127960

410

DAS

27

9-89

14/9/10

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Page 3

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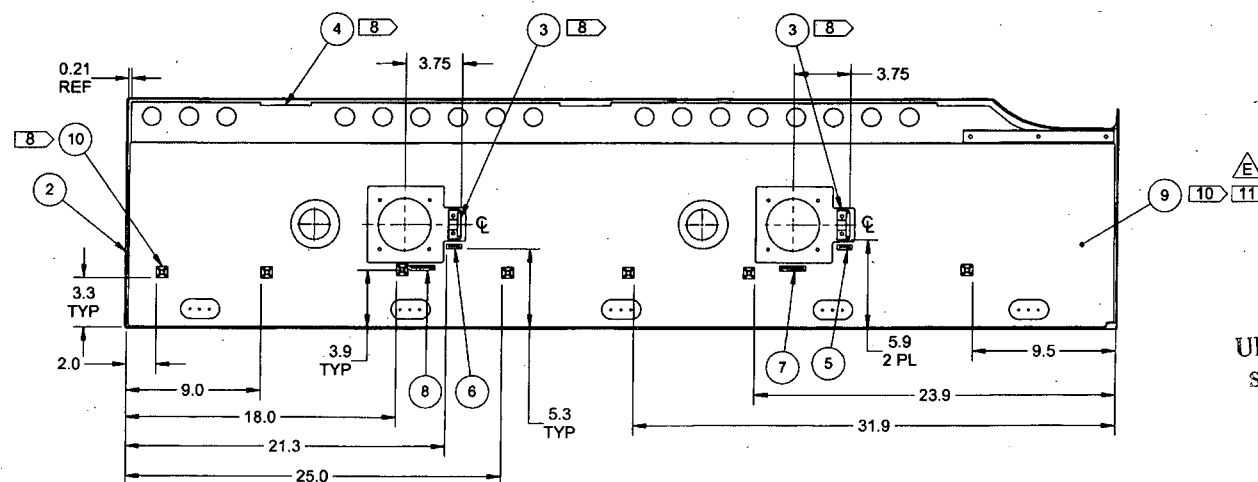
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ITEM NO.	QTY. -141	PART NUMBER	DESCRIPTION
1	X	D4635-141	LH, FWD CEILING REPLACEMENT PANEL ASSY
2	1	D4635-1	LH, FWD CEILING PANEL
3	2	D4669-1	BRACKET
4	1	D4695-041	LH CHANNEL ASSEMBLY
5	1	D4732-5	LABEL
6	1	D4732-9	LABEL
7	1	D4732-29	LABEL
8	1	D4732-33	LABEL
9	1	D5022-1	FOAM, SIDE PANEL, FWD
10	7	MPNY-750S-9-C	MOUNTING PAD



D4635-141 LH, FWD CEILING REPLACEMENT PANEL ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122576 MLT
140723

RELEASED
2014-01-22

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART)
TO BOND D4669-1, D4695-041 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5022-1 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5022-1 FOAM ON D4635-1

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. E
MFG. APPR.	DC	D4635	SHEET 9 OF 18
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	OUTBOARD CEILING PANELS	NTS
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